

## Forming Tap M3

A10-150

The excentrical form of the tap is freely designable based on DXF, as well as the diameter along the thread. Pregrinding and Finishing using appropriate vitrified wheels combined with dressing on diamondrolls leads to a very effective and rapid process. The high speed process is fully supported by the powerful Fanuc control and its optimised parameters.



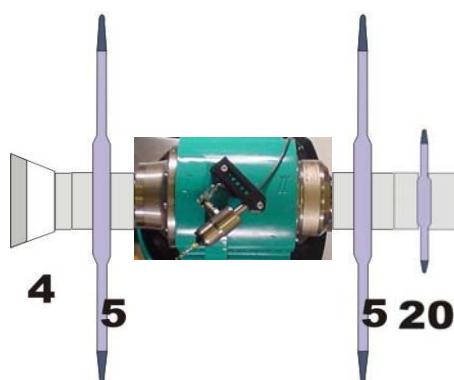
### 1. Cycletime for Production

Tool specifications				
Diameter 3.15 mm, Length of cutting edge 24 mm				
Material HSS				
Operations	Point Tip	Thread Pregr.	Thread Finish	Thread O.D.
Feed [mm/Min]	150	8000	9000	9000
Power [kW]	1	1	1	1
Cutting feed [m/s]	32	50	50	24
Used wheels	4	5	20	5
Grinding time [s]	11	45	40	40
Total cycle time	2 Min 16			

The mentioned cycle times are indicative. The material to be ground, different grinding wheels or other coolants can influence the cycle times considerably.

### 2. Used Grinding Wheels

4 Ø75 11V9 B126  
5 Ø200 14EE1 C280  
20 Ø150 14EE1 C280



### 3. Machine and Software Requirements

Machines: 5 axes CNC grinders : GEMINI DMR

automatic Tailstock and Steadyrest Dressing unit

Control: Fanuc 31i

Coolant: Synthetic Oil, pressure 10 bar

Software: Quinto 5

responsible engineer: OP, 18.3.07

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